

# Work Order ID 73012

Tuesday, August 23, 2011 3:08:59 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 11-08-23 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580-041

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

Handwritten signature/initials

11-9-13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

DL  
4/09/13

1 0 3E11/10/05

**Dart Aerospace Ltd**

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Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI004  
A/R□□□ Aluminum Rod mill 736

*BE 11/10/05*

2-Grind welds on step as per Dwg D2580

3-Weld spacers as per dwg D2580

*BE 11/10/05*

3- \*\*\* N/A\*\*\*\* Insert D4202-1 spacer, swage as per QSI002 and trim/ grind  
flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2  
x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

*Carried DL 11/10/06*

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Deburr

*3 DL 11/10/06*

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

*11-10-11*

*C-Bore*

**Dart Aerospace Ltd**

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Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00							
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
170  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00  0.00							

5/11/13

11 10 13 13

1x of m-1 11/10/13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

4:00 0.00  
320 0.00  
4:30

*X Ø m-f 11/10/13*

190

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

*1 11-10-17.*

**Dart Aerospace Ltd**

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Reference:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates  
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 118393 ☐ ☐  
Sikaflex expire date: 12-5

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive  
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 118393 ☐ ☐  
Sikaflex expire date: 12-5

5-Wing Walk as per Dwg D2580 and QSI 005 4.4  
Batch: 118988

1 BL 11-10-17.

**Dart Aerospace Ltd**

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00  0.00							
220  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: <u>PPA 73387</u>	0.00  0.00							
230  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

8/11/2011

8/23/11

11/10/2011  
MF 11-10-19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Tuesday, August 23, 2011 3:09:03 PM

Page 1

Work Order ID: 73012

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30  
KJ IPP Rev P 10.02.19  
per PAR09-043 EC verified by:DD  
IPP Rev: O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q  
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1 *D 2579*



Spacer

Manufactured	No	140	Each	443.0000	20	20
--------------	----	-----	------	----------	----	----

Location	Loc Qty	Loc Code
LG002	443	
66929	106	
67129	196	
67308	1	
67430	140	

*BE 11/10/05*  
*B 73751 -20*

D2580-1



205 Skidtube bent detail

Manufactured	No	110	Each	4.0000	1	1
--------------	----	-----	------	--------	---	---

Location	Loc Qty	Loc Code
LG <i>B72965</i>	4	
72840	4	

*①*

*DP 11-9-13*

D2576-3



Step (maching detail)

Manufactured	No	140	Each	27.0000	1	1
--------------	----	-----	------	---------	---	---

Location	Loc Qty	Loc Code
LG	27	
66156	27	

*1*

*BE 11/10/05*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 73012

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured

No

200

Each

28.0000

1

1



Cap



BR 11-10-17.

## Location

## Loc Qty

## Loc Code

FP007

28

65519

2

65569 ✓

26

AN3-5A

Purchased

No

200

Each

1,029.000

2

2



Bolt



BR 11-10-17.

## Location

## Loc Qty

## Loc Code

ST350

1029

115371

46

117423

683

118626

300

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

0.0000

2

2



Washer



BR 11-10-17.

ALS7-1032-130

Purchased

No

200

Each

1,155.000

50

50



Insert



## Location

## Loc Qty

## Loc Code

ST282

1155

117717

899

118386

256

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Shop Packet Print

Page 2

**Dart Aerospace Ltd**

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Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

200

Each

2,261.000

50

50



BOLT



BR 11-10-17

## Location

## Loc Qty

## Loc Code

ST350

2261

117313

2

117688

36

117795

1

117872

22

118012

20

118112

40

118451 ✓

1000

118628

1140

50.

AN960C10L

\* NAS1149C0332 ✓  
R

Purchased

No

200

Each

0.0000

50

50



washer

D3566-13

Manufactured

No

200

Each

23.0000

1

1



Gasket

118354.



50.

BR 11-10-17.

## Location

## Loc Qty

## Loc Code

FP

4

69281

4

FP014

19

68341

1

72149 ✓

18

1

BR 11-10-17.

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Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

200 Each

22.0000

1 1



Gasket



BR 11-10-17

## Location

## Loc Qty

## Loc Code

FP015

22

68961

1

71601

1

72849 ✓

20

D3566-1

Manufactured No

200 Each

24.0000

2 2



Gasket



BR 11-10-17

## Location

## Loc Qty

## Loc Code

FP015

24

68924

2

72848

22

D3564-11

Manufactured No

200 Each

13.0000

1 1



Wearshoe



BR 11-10-17

## Location

## Loc Qty

## Loc Code

FP020

13

72207 ✓

13

D3564-13

Manufactured No

200 Each

8.0000

1 1



Wearshoe



## Location

## Loc Qty

## Loc Code

FP016

2

69280

2

FP017

6

71594

6

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Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-9

Manufactured No

200

Each

14.0000

1

1



Wearshoe



BR 10-10-17

Location

Loc Qty

Loc Code

FP019

73345

5

67590

4

69943

1

FP020

9

72208

9

D3564-5

Manufactured No

200

Each

12.0000

1

1



Wearshoe



BR 11-10-17

Location

Loc Qty

Loc Code

FG

73330

2

34806

2

FP019

10

72164

10

D2594-3

Manufactured No

200

Each

548.0000

16

16



O-Ring, 205 Skidtube



BR 11-10-17

Location

Loc Qty

Loc Code

FP-A

548

65518

41

66952

507

16

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Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

242.0000

16

16



Plug, 205 Skidtube



BL 11-10-17.

## Location

## Loc Qty

## Loc Code

FP-A

242

42807

28

67441

7

68943

6

72127 ✓

201

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
16

Tuesday, August 23, 2011 3:09:04 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>RH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07.06.28 *[Signature]***DEO ATTACHED****UNDER REVIEW***P1106590*  
RMV *P11.06.30*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *73012**P11 08-23***GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

RELEASED  
07-06-28

~~DEO ATTACHED~~

Technical drawing of a circular component with a central hole and a rectangular slot. The drawing includes dimension lines and labels for various parts and assembly steps:

- #0.208**: Dimension for the central hole.
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Instruction for drilling two locations.
- SEAL WITH SIKAFLEX-241/-291**: Instruction for sealing the component.
- AN3-5A BOLT (1)**: Label for the bolt used in the assembly.
- AN960D10L WASHER (1)**: Label for the washer used in the assembly.
- (2 PLACES)**: Dimension for the distance between the two drilling locations.
- D2855 CAP**: Label for the cap used in the assembly.
- 0.40**: Dimension for the width of the rectangular slot.

Diagram illustrating the components of a wheel assembly:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)

After Perform:

1. CH
2. IN
3. WE
4. C'E

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750

1.750

0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0

91.500

190.0  
(D2500-1)

[illegible]

D3560-V41 ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

8

1.5

1.5

1.5

P

P

P

P

P

P

P

REFER TO DETAIL C

D3566-1

D3566-5

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)  
AN560C10L WASHER (1)  
(50 PLACES)

DESIGN	DRAWN BY
--------	----------

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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APPROVED

\_\_\_\_\_

**PART**

**DART AEROSPACE LTD.**  
MARKHAM, ONTARIO, CANADA

DRAWING NO.

D2580

TITLE	205 SKIDTUBE ASSEMBLY
-------	-----------------------

REV. 0

SHEET 2 OF 3

SCALE

11.06.30  
RMV 01.06.30

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

RELEASED  
07-06-28

RMV 6P<sub>H.06.30</sub>

DRILL PRIOR TO D2855 CAP  
INSTALLATION (2 PLACES)

AN3-5A BOLT (1)  
AN960UD10L WASHER (1)  
(2 PLACES)

D2855 CAP

SEAL WITH  
SIKAFLEX-241/-291

SEE NOTE ii)

0.40

D2579 SPACER

WEB (REF)

.130 (REF)  
(NO PLACES)

AFTER PERFORM

1. CHA
2. INS
3. WEI
4. C'E

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750 1.750

#0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750  
17.375  
26.000  
34.188

57.313 (REF)  
7 EQUAL SPACES  
8.168 PITCH

38.0 91.500

190.0  
(D2500-1)

[illegible][illegible]

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN	A
CHECK	
DATE	07.0

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**DART** DART AEROSPACE LTD.  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. D
D2580	SHEET 3 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24



NO. 271

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 72859  
Part number: 205-634-041  
Description: 205 Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Lum Date of Test Coupon 11-10-12  
Welder Barclay Elliott Date of Test Coupon 11-10-12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld